

Work Order ID 68207

Friday, April 08, 2011 11:48:45 AM



Page 1

Item ID: D412-698-025

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Panel Door Roller, LH/RH

Start Date: 4/8/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-8

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9409	Rev B								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP DSI9409

CHG001

110

0.00



Pick Kit

Memo

0.00

Packaging

Packaging

120

0.00



QC4- 100% Inspect kits for completeness

Memo

0.00

QC

Quality Control

S 11-04-8

11-04-8

11/04/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68207

Friday, April 08, 2011 11:48:45 AM



Page 2

Item ID: D412-698-025

Accept



Setup Start



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Start Date: 4/8/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00				11/4/20			
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-031 □ Location: 21 □ PPP Rev: B								
140 	QC21- Final Inspection - Work Order Release	0.00						11/5/3	
QC	Memo	0.00							
Quality Control									

11/09/29
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, April 08, 2011 11:48:52 AM

Page 1

Work Order ID: 68207

Parent Item: D412-698-025

Parent Item Name: Hinge Panel Door Roller, LH/RH

Start Date: 4/8/2011

Required Date: 4/12/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 08.07.03 EC verified by:LL
IPP Rev:B 08-09-10 add D3121-143 & remove 1 D3121-144 DD verified by:JLM
IPP Rev C 09.01.20 per DSI 9409 rev B EC verified DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S D3121-143 Bracket Assembly		Manufactured	No			120	Each	7.0000	1 2 ✓				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235A				7					
				61406				7		61406			
S D3121-144 Bracket Assembly		Manufactured	No			120	Each	1.0000	1 2 ✓				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235A				1					
				61728				1					
S D3202-5 COVER		Manufactured	No			120	Each	5.0000	1 2 ✓				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST181				5					
				45213				5		45213			
S D3238-13 Plate		Manufactured	No			120	Each	4.0000	4 8 ✓				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST046				4					
				42227				4		42227			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, April 08, 2011 11:48:52 AM

Page 2

Work Order ID: 68207

Parent Item: D412-698-025

Parent Item Name: Hinge Panel Door Roller, LH/RH

Start Date: 4/8/2011

Required Date: 4/12/2011

Start Qty: 2.00

Required Qty: 2.00

D3238-3

Manufactured No

120 Each

10.0000

2

4

✓



Plate

Location

Loc Qty

Loc Code

ST042

10

42229

10

120 Each

27.0000

2

4

✓

D3675-3

Manufactured No



SLIDING DOOR BRACKET

Location

Loc Qty

Loc Code

ST236A

27

45062

27

42229

45062

JB

JB 11/04/19

Friday, April 08, 2011 11:48:53 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

SUPPLEMENTAL TO INSTALLATION INSTRUCTIONS IIN-D412-698 REV. E &
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-698 REV. 5
(REF. TCCA STC SH92-43, FAA STC SR01446NY & EASA STC EASA.IM.R.S.00709)

REFERENCE ONLY

PURPOSE

THE PURPOSE OF THE D412-698-025 KIT IS TO ALLOW OPERATORS THAT HAVE PERFORMED THE BELL/AUGUSTA SERVICE INSTRUCTION TA212-138/2-22B TO THE LH/RH CABIN DOORS TO REPLACE THE EXISTING P/N 205-031-435-001 & 205-031-435-002 ROLLERS WITH DART P/N D3121-143 & D3121-144 ROLLERS. THIS KIT ALSO REPLACES THE EXISTING DOOR TRACK WITH SEGMENTED "J" BRACKETS DART P/N D3675-3 (SEE FIGURE 3 FOR THE LOCATION OF BOTH CHANGES).

THERE IS A NEGLIGIBLE WEIGHT CHANGE ASSOCIATED WITH THIS MODIFICATION.

PROCEDURE

- 1.) REMOVE HINGE PANEL DOOR PER AIRCRAFT MAINTENANCE MANUAL.
- 2.) REMOVE BELL P/N 205-031-435-001 AND 205-031-435-002 ROLLERS. RETAIN HARDWARE IF AIRWORTHY.
- 3.) REMOVE THE BELL/AUGUSTA DOOR TRACK. RETAIN HARDWARE IF AIRWORTHY.
- 4.) INSTALL DART P/N D3121-143 & D3121-144 USING EXISTING HARDWARE AND SHIMS IF AIRWORTHY. REPLACE EXISTING BELL SHIMS IF NO LONGER AIRWORTHY WITH WITH DART P/N D3238-3/-13 AS REQUIRED (SEE FIGURE 1). TORQUE FASTENERS PER AIRCRAFT MAINTENANCE MANUAL.
- 5.) INSTALL THE DART P/N D3675-3 SLIDING DOOR BRACKETS ("J" BRACKETS) & THE D3202-5 COVER, PER FIGURE 2 USING EXISTING HARDWARE. TORQUE FASTENERS PER AIRCRAFT MAINTENANCE MANUAL.
- 6.) RE-INSTALL MODIFIED DOOR ON AIRCRAFT PER AIRCRAFT MAINTENANCE MANUAL.
- 7.) CHECK SLIDING OPERATION OF DOOR. ADJUST POSITION/SHIMMING OF ALL NEW BRACKETS UNTIL DOOR OPERATION IS SMOOTH AND FREE OF DRAGGING/BINDING THROUGH FULL TRAVEL OF DOOR. RE-TORQUE ALL FASTENERS PER AIRCRAFT MAINTENANCE MANUAL.




NOTE: ENSURE VERTICAL ROLLERS ARE SITTING FLUSH TO THE DOOR TRACKS TO PREVENT ROLLER WEAR AND PREMATURE DOOR TRACK WEAR.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-0-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 08.11.04
CERT. NO.: SH92-43
ISSUE NO.: 5

B	ADD D3202-5 & D3675-3 & (COVER & "J" BRACKETS) CUSTOMER REQUEST TO REPLACE BELL/AUGUSTA MOD PARTS.	AJS	08.11.04
A	NEW ISSUE	AJS	08.07.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9409	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		HINGE PANEL ROLLER KIT	NTS
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D3121-144 BRACKET ASSEMBLY

D3121-143 BRACKET ASSEMBLY

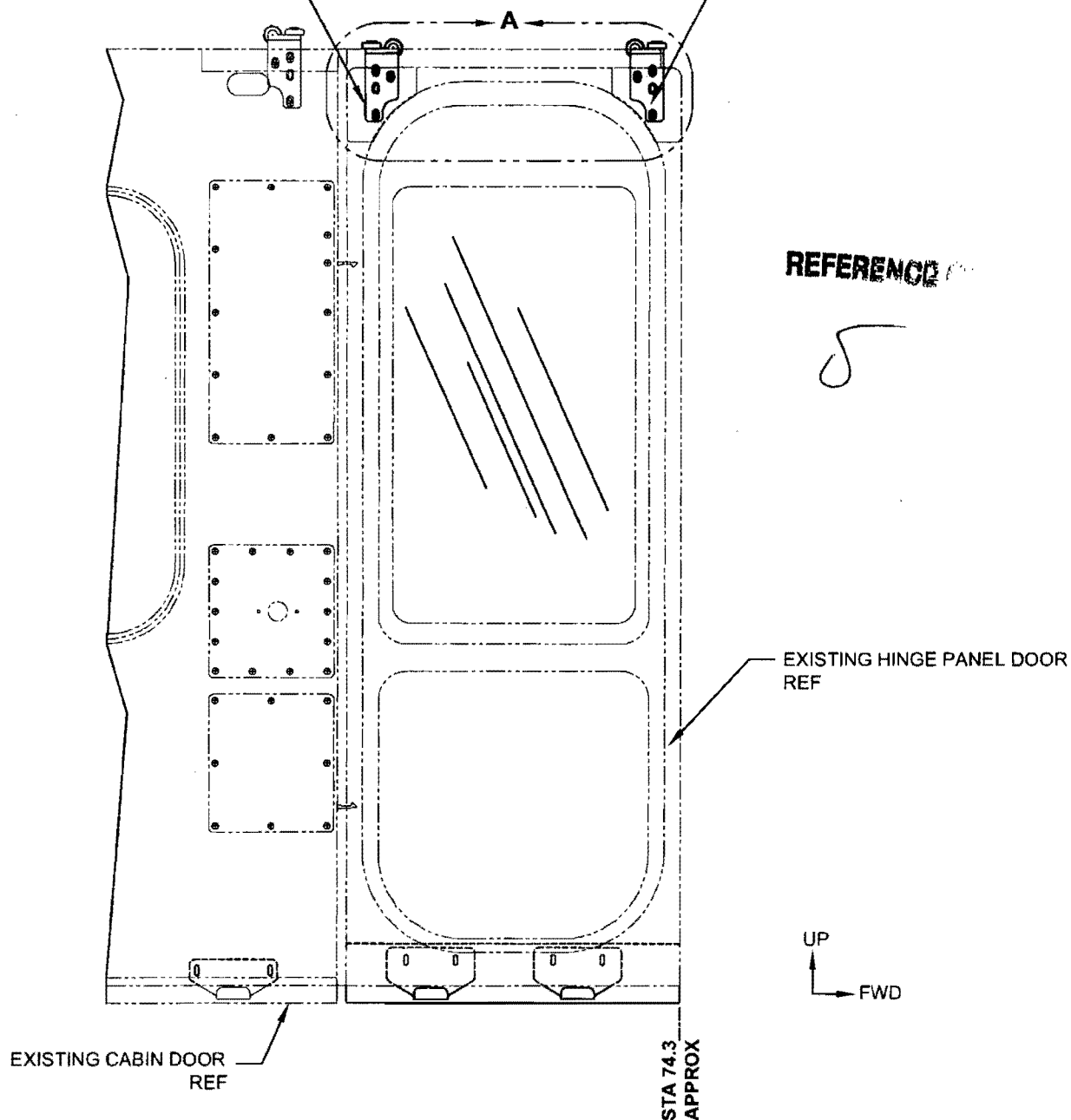





FIGURE 1. D412-698-025 HINGE PANEL DOOR ROLLER KIT
(VIEW OF L/H HINGE PANEL DOOR LOOKING OUTBOARD, R/H DOOR OPPOSITE)

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 08.11.04
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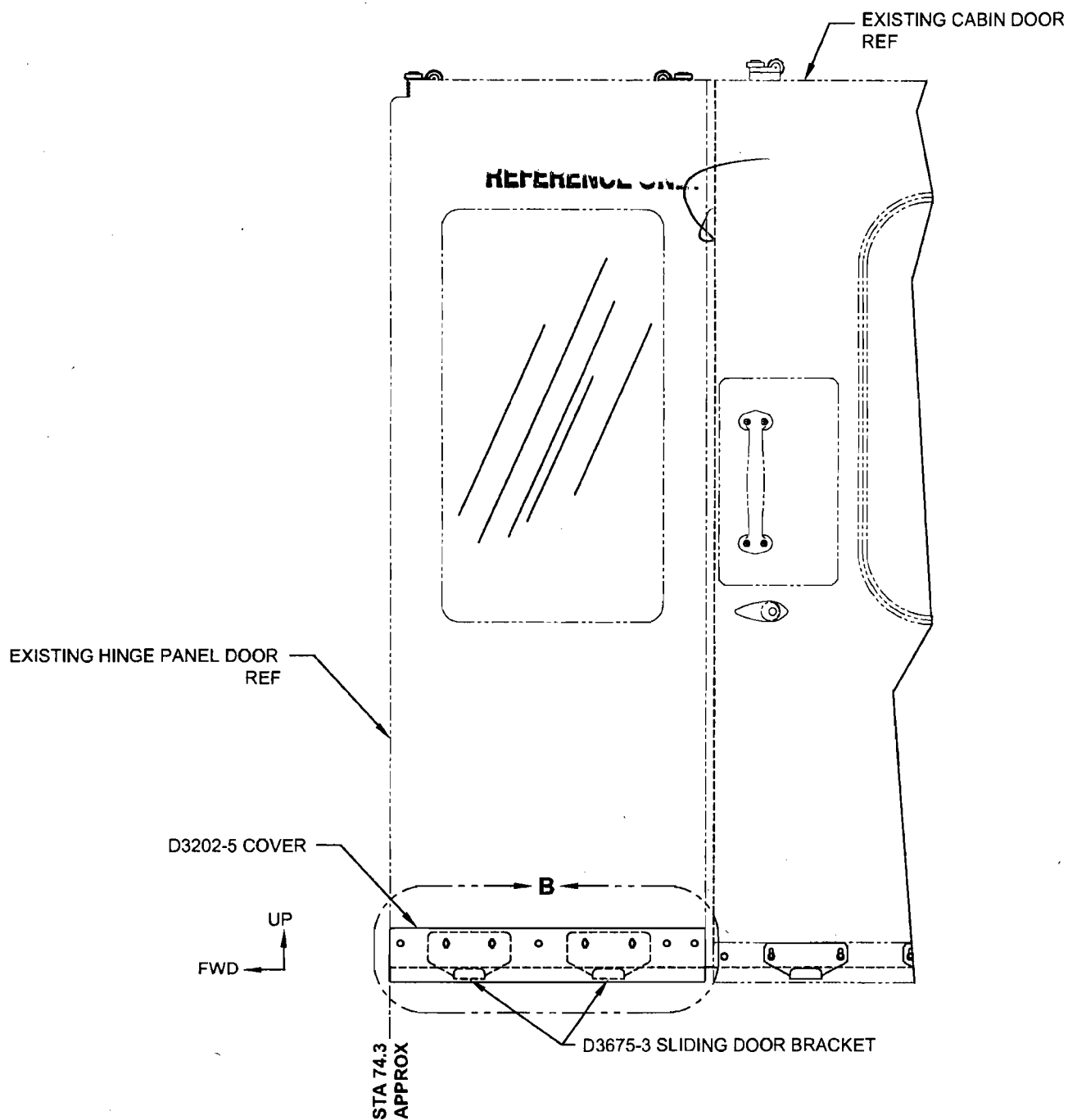





FIGURE 2. D412-698-025 HINGE PANEL DOOR ROLLER KIT
(VIEW OF L/H HINGE PANEL DOOR LOOKING INBOARD, R/H DOOR OPPOSITE)

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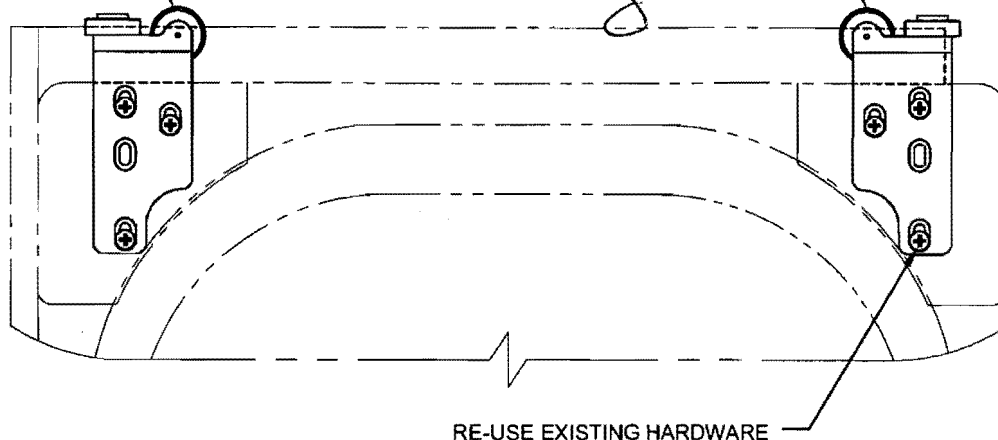
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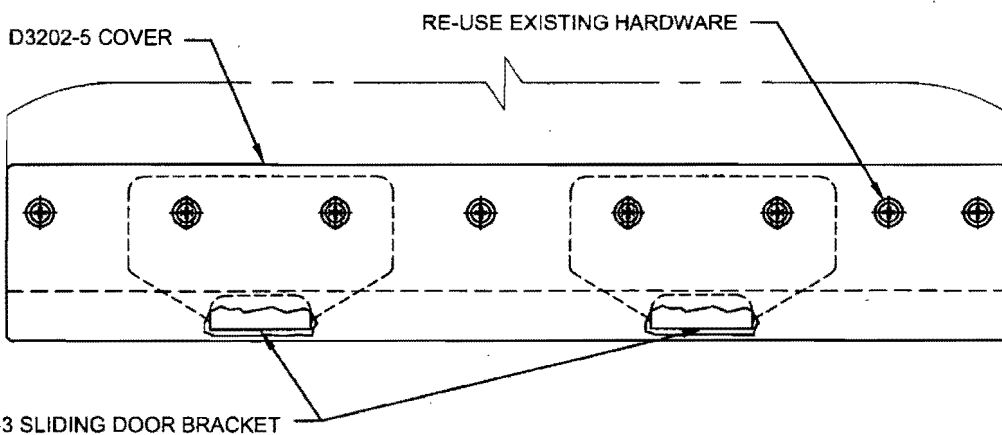
(1) D3121-144 BRACKET ASSEMBLY REF
 (1) D3238-3 SHIM (AS REQUIRED)
 (1) D3238-13 SHIM (AS REQUIRED)
 LOCATE FROM EXISTING
 FASTENER HOLES

(1) D3121-143 BRACKET ASSEMBLY REF
 (1) D3238-3 SHIM (AS REQUIRED)
 (1) D3238-13 SHIM (AS REQUIRED)
 LOCATE FROM EXISTING
 FASTENER HOLES

REFERENCE JNL



DETAIL A VIEW ON L/H HINGE PANEL DOOR (LOOKING OUTBOARD)
 (RH DOOR OPPOSITE)



DETAIL B VIEW ON L/H HINGE PANEL DOOR (LOOKING INBOARD)
 (RH DOOR OPPOSITE)

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 DEPARTMENT OF TRANSPORT
 AIRCRAFT CERTIFICATION
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 DAO # 01-O-01

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BY: *[Signature]*
 D. SHEPHERD (DE # 02)

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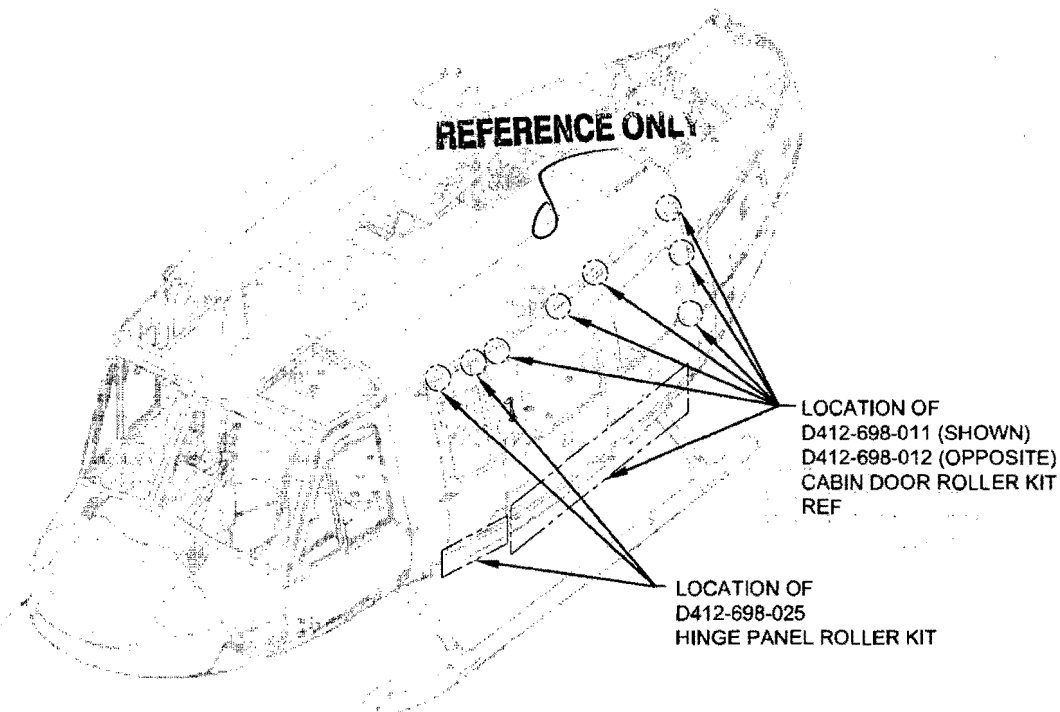


FIGURE 3. LOCATION OF D412-698-025 HINGE PANEL ROLLER KIT
(D412-698-011/-012 SHOWN FOR REFERENCE ONLY)

TABLE 1. PARTS LIST FOR D412-698-025

QTY -025	PART NUMBER	DESCRIPTION
X	PART NUMBER	HINGE PANEL DOOR ROLLER KIT (FITS L/H OR R/H DOOR)
1	D3121-143	BRACKET ASSEMBLY
1	D3121-144	BRACKET ASSEMBLY
1	D3202-5	COVER
2	D3238-3	SHIM
4	D3238-13	SHIM
2	D3675-3	SLIDING DOOR BRACKET

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BRANCH
DAO # 01-O-01

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